

Date: Wednesday 30/07/2008 5:31:35 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y RH		
Job Number	: 40824			Part Number	: D412769044		
Estimate Number	: 13314			Drawing Number	: D412-769-2 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 15/08/2008		
Previous Run	: 40001			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	: <u>Jul 087.31</u>						
Comment	: Est rev A 08.05.12 new issue DD verified by:ec						
	: Est Rev:B 08-07-17 revB as per dwg DD verified by:ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
<b>Comment:</b> PACKAGING RESOURCE #1			
Pick Packing Kit			
2.0	D3782045	Back Leg Assembly	
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Back Leg Assembly batch: <u>B40873</u>			
3.0	D3782041	Front Inboard Leg Assembly	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
Front Inboard Leg Assembly batch: <u>B40870</u>			
4.0	D3782044	Front Outboard Leg Assembly, RH	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
Front Outboard Leg Assembly, RH batch: <u>B40872</u>			
5.0	D3783041	Lateral Brace Assembly	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
Lateral Brace Assembly batch: <u>B40874</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3783043 Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: B 40875

SB

7.0 D3783045 Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B 40874

SB

8.0 D3784041 Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: B 40877

SB

9.0 D3784043 Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: B 40878

SB

10.0 D3784044 Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: B 40879

SB

11.0 D37662 Front Rail, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: B 40864

SB

12.0 D37663 Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B 40710

SB 08/08/20 ⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B40711

SB 08/08/20 ①

14.0 D37921 Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B40209

15.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108077

SB

16.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M107938

SB

17.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M108471

SB

18.0 AN513A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

SB

19.0 AN960JD10 Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M108558

(or NAS1149D0363J) batch:

SB 08/08/20 ①

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0 AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108161

(or NAS1149D0463J) batch:

SB

21.0 AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M108244

(or NAS1149D0568J) batch:

SB

22.0 AN52510R24

Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

SB

23.0 MS21042L3

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M108764

SB

24.0 MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107499

SB

25.0 MS21042L5

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108471

SB 08/08/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08/08/21

(1)

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (40)

(2)

28.0 POWDER COATING POWDER COATING



M 106442

(12)

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15

OVEN TEMPERATURE:

320° F

FINISH TIME:

10:45

M 106442 08/08/21

(3)

29.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 08/08/21

(3)

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751 Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch:

B 40658

FF 08/08/21 (3)

31.1 D3792-1 Seat belt eye bolt

Qty 3

batch: B 40209

08/08/21  
(perm. change)

SB 08/08/21 (3)

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D37741

Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40587

FF 08/08/21

①

33.0

D37743

Seat Back, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40588

FF 08/08/21

①

34.0

AN525 10R22

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: M108270 M107936

FF 08/08/21

①

35.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: \_\_\_\_\_

(or NAS1149D0332J) batch: M105793

FF 08/08/21

①

36.0

MS21042L3

Nut



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M108764x13 / M108747x6

FF 08/08/21

①

37.0

AN35A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100100

FF 08-08-21

①

38.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-2

FF 08/08/21

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

39.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/08/21 (Y)

40.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 4680U

AS 08/08/22 (P)

41.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/22 (P)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

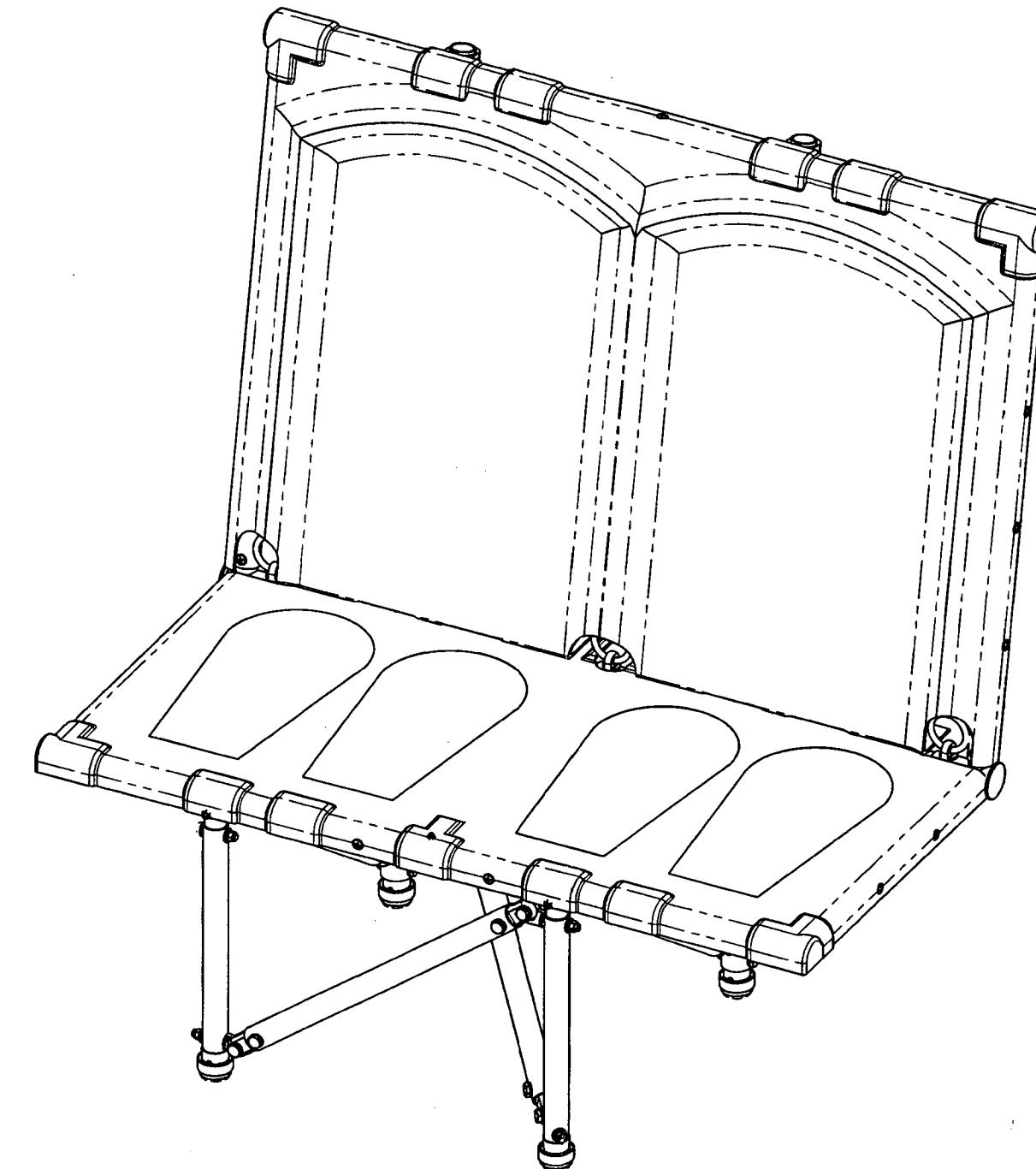
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B

A



D412-769-044 AFT FACING SEAT, RH

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08-07-1011  
M

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WITHOUT NOTICE  
WORK ORDER  
NO. 40821

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	M	DRAWING NO.	REV. B
MFG. APPR.	M	D412-769-2	SHEET 1 OF 7
APPROVED	M	TITLE	SCALE
DE APPR.	M	AFT FACING SEAT ASSY, RH	
DATE	08.06.25	NTS	

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8 7 6 5 4 3 2 1

D

D

C

C

B

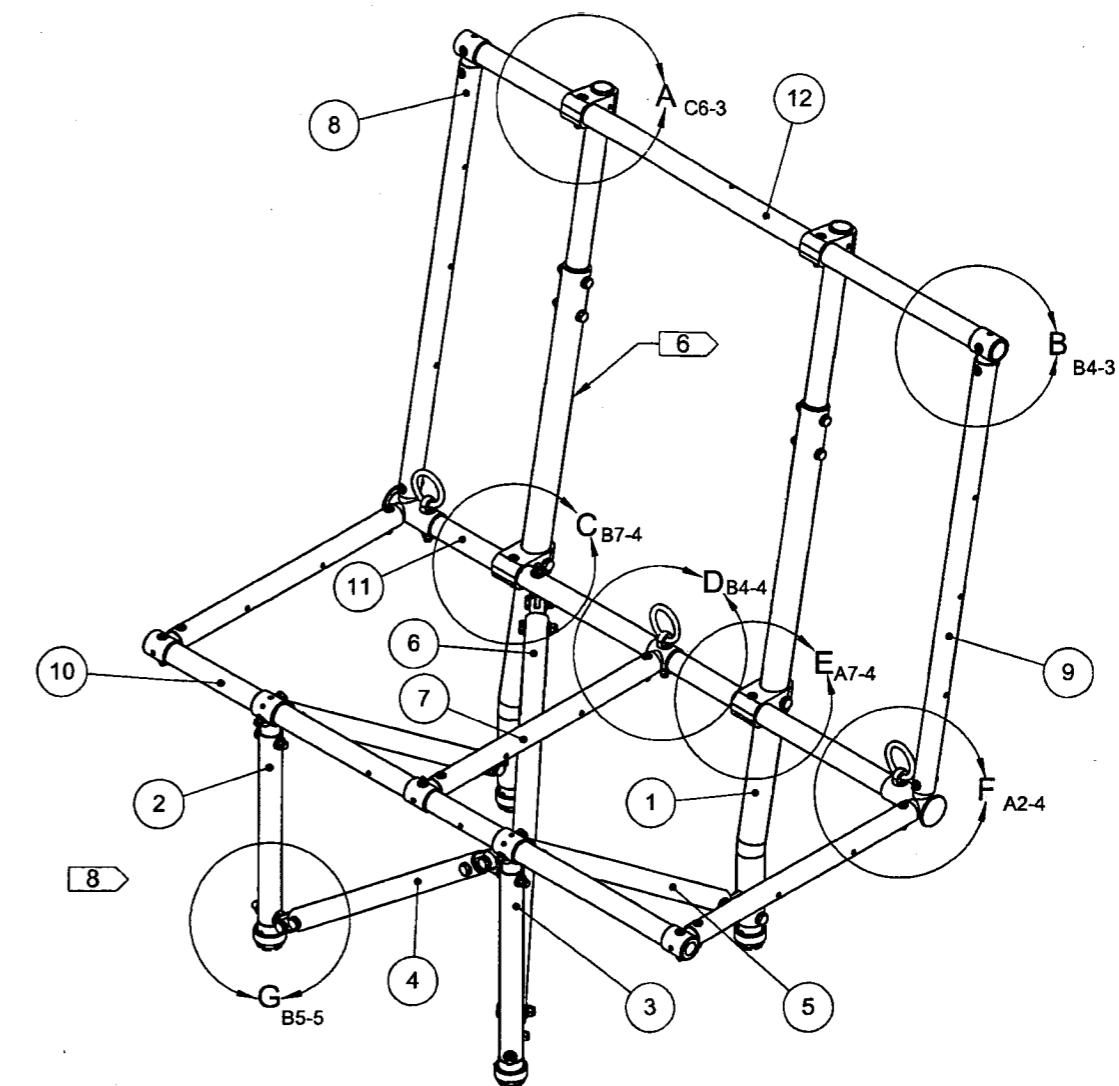
B

A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

B



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

**D412-769-044 AFT FACING SEAT, RH**

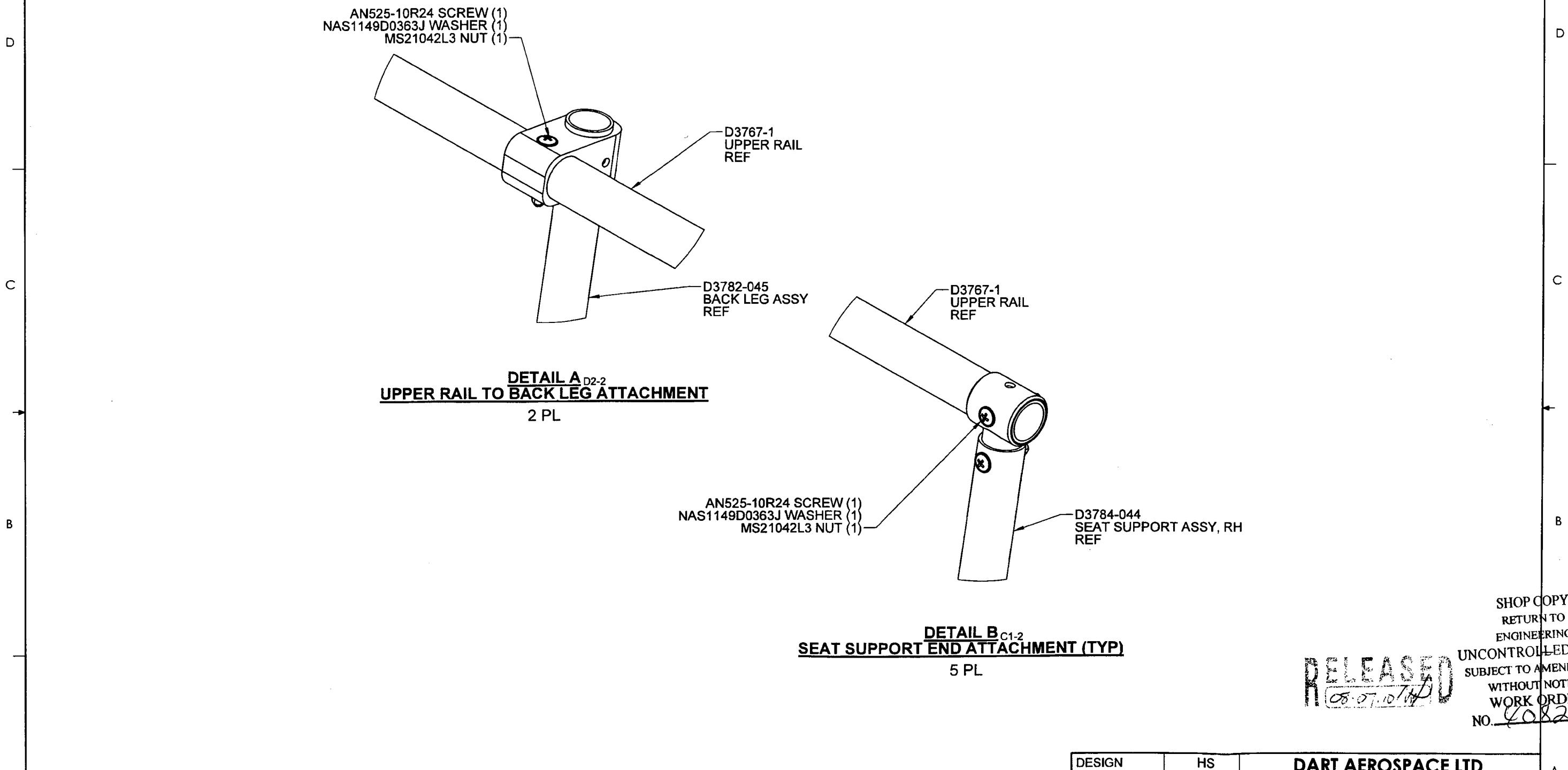
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WORK ORDER  
NO. 40004

DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PP	DRAWING NO.			
MFG. APPR.	MM	REV. B			
APPROVED	MM	D412-769-2			
DE APPR.	MM	SHEET 2 OF 7			
DATE	08.06.25	TITLE			
		SCALE			
		AFT FACING SEAT ASSY, RH			
		NTS			
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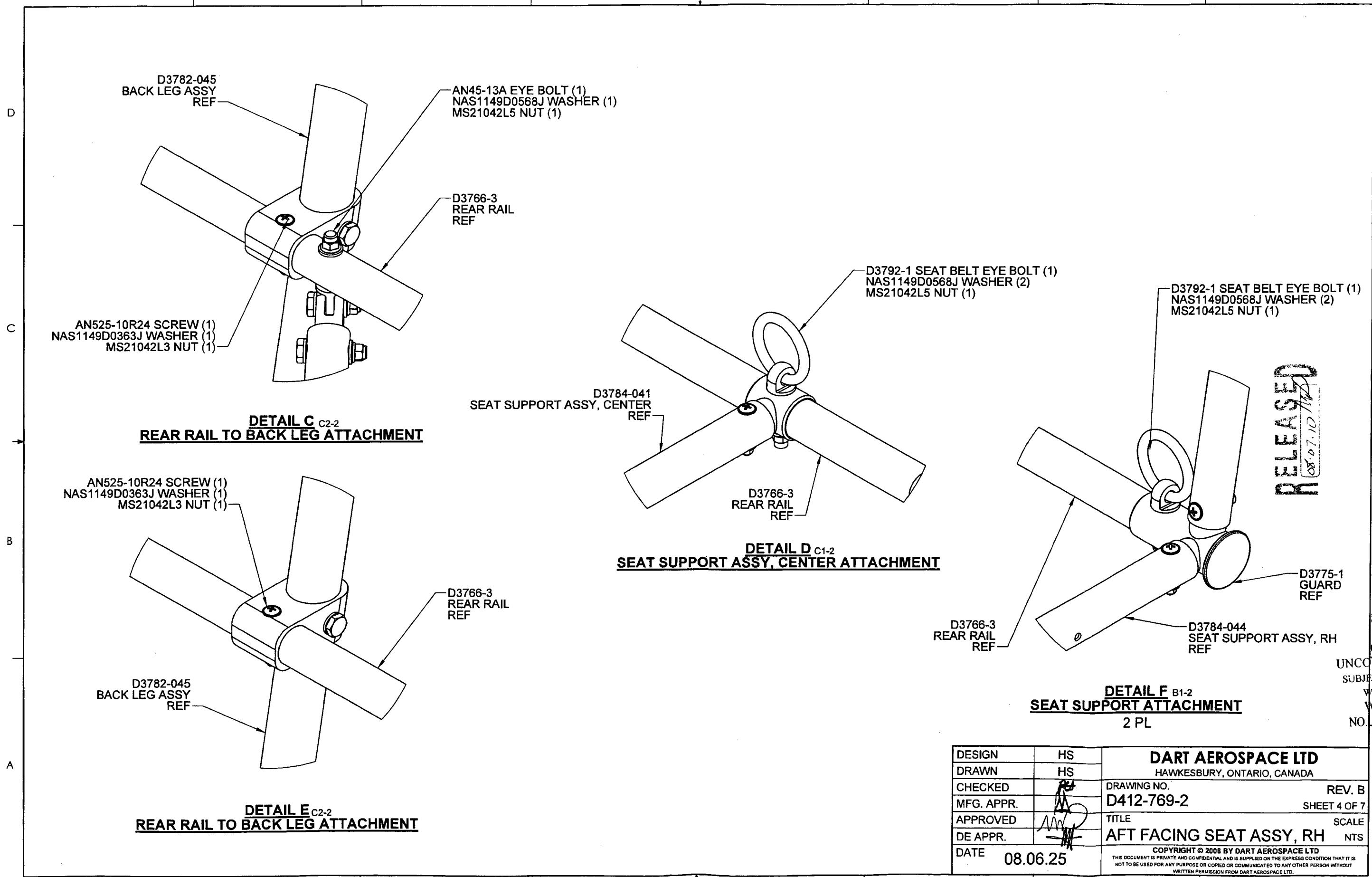


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08-07-10  
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WORK ORDER  
NO. 40824

DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	P4	DRAWING NO.			
MFG. APPR.	M	D412-769-2	REV. B		
APPROVED	M	SHEET 3 OF 7			
DE APPR.	M	TITLE			
DATE	08.06.25	AFT FACING SEAT ASSY, RH			
NTS					
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

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D

C

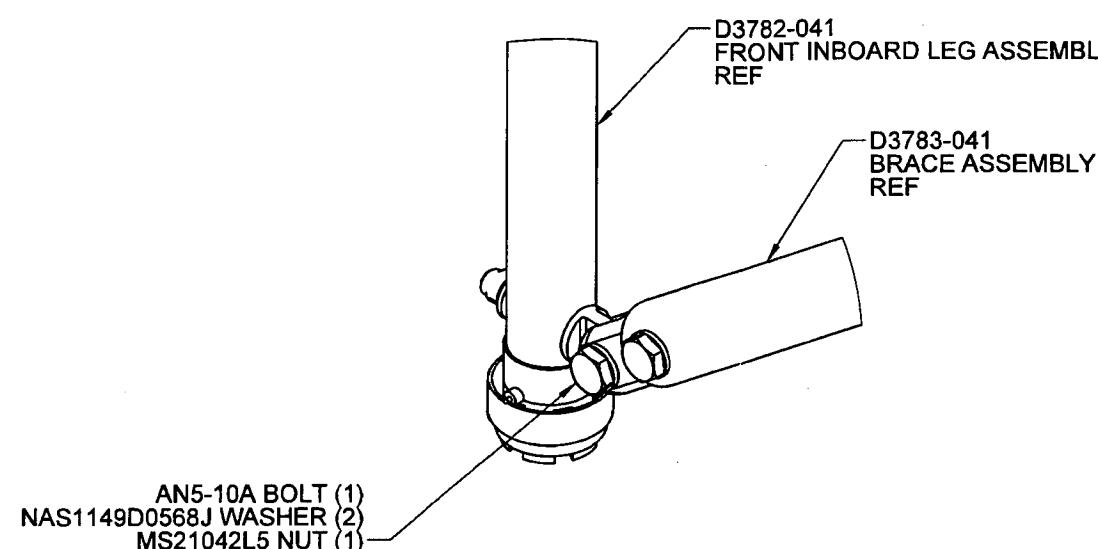
C

B

B

A

A



**DETAIL G<sub>B3-2</sub>**  
**BRACE ATTACHMENT**

6 PL

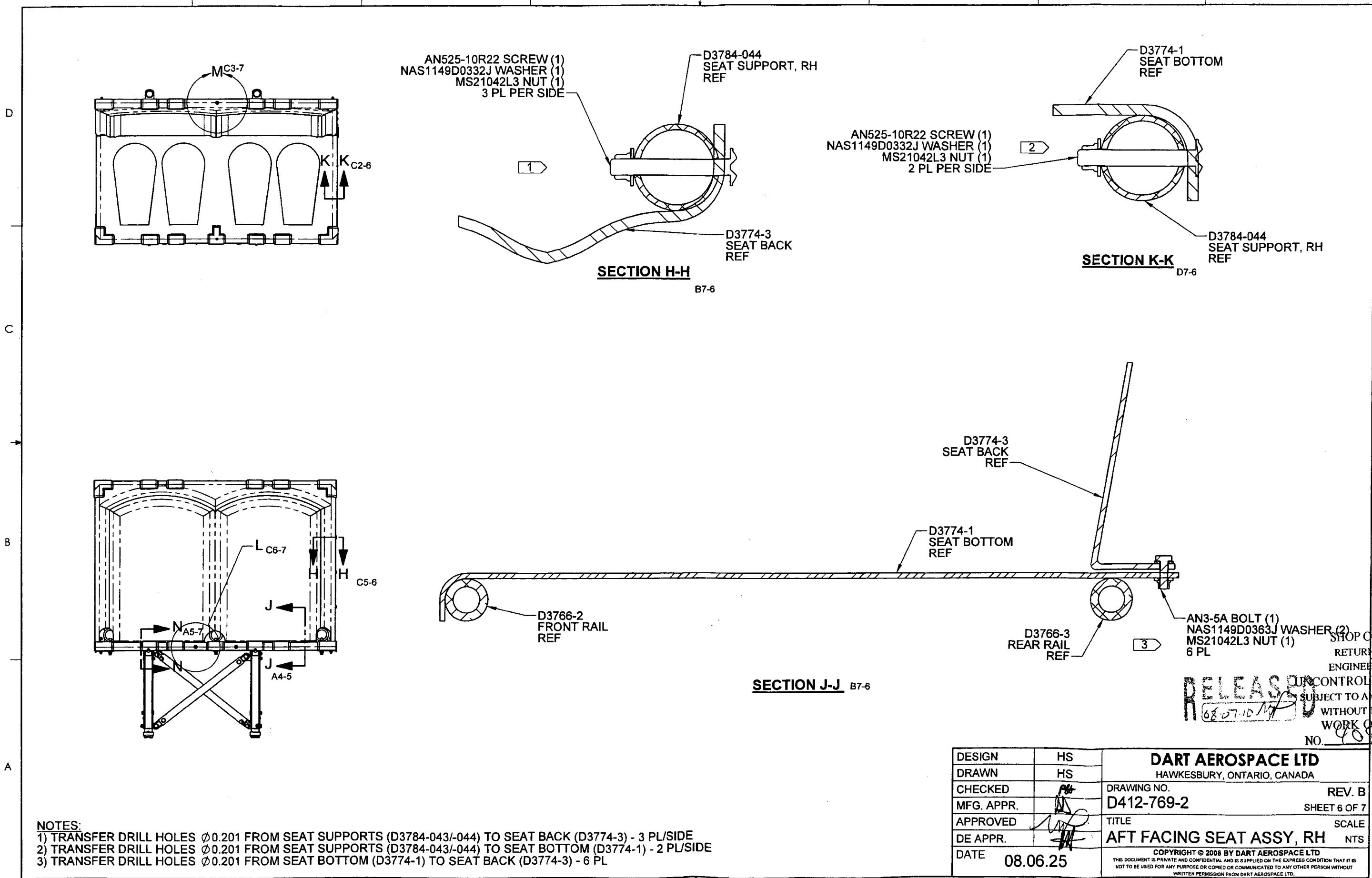
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WITHOUT NOTICE  
WORK ORDER  
NO. 40824

DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PT	DRAWING NO.			
MFG. APPR.	AM	D412-769-2	REV. B		
APPROVED	SM	SHEET 5 OF 7			
DE APPR.	MM	TITLE			
DATE	08.06.25	SCALE			
AFT FACING SEAT ASSY, RH					
NTS					

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



DESIGN	HS	DART AEROSPACE LTD
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CHECKED	<i>AS</i>	DRAWING NO.
MFG. APPR.		D412-769-2
APPROVED	<i>AS</i>	REV. B
DE APPR.	<i>AS</i>	SHEET 6 OF 7
DATE	08.06.25	SCALE
		NTS

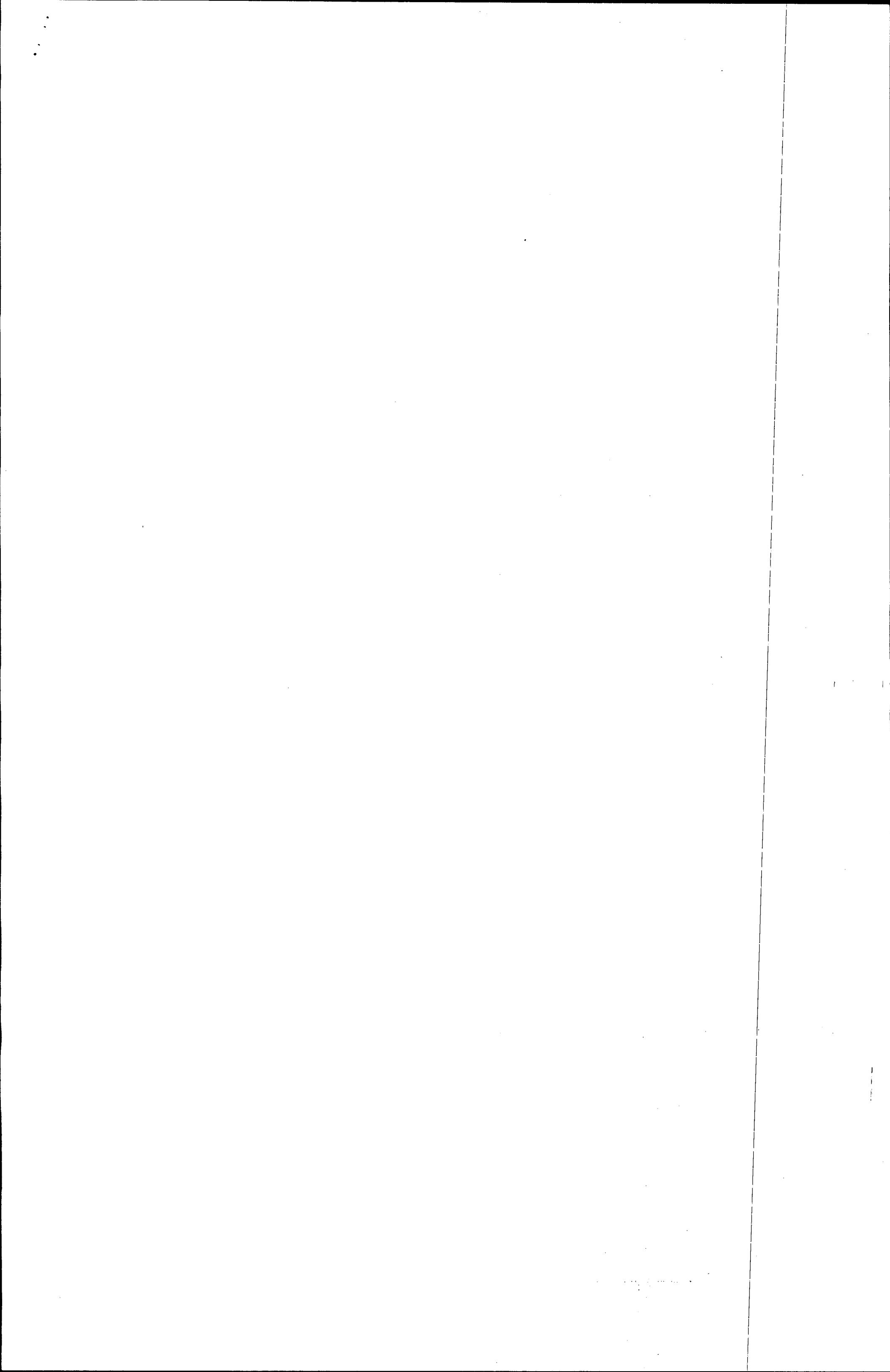
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D

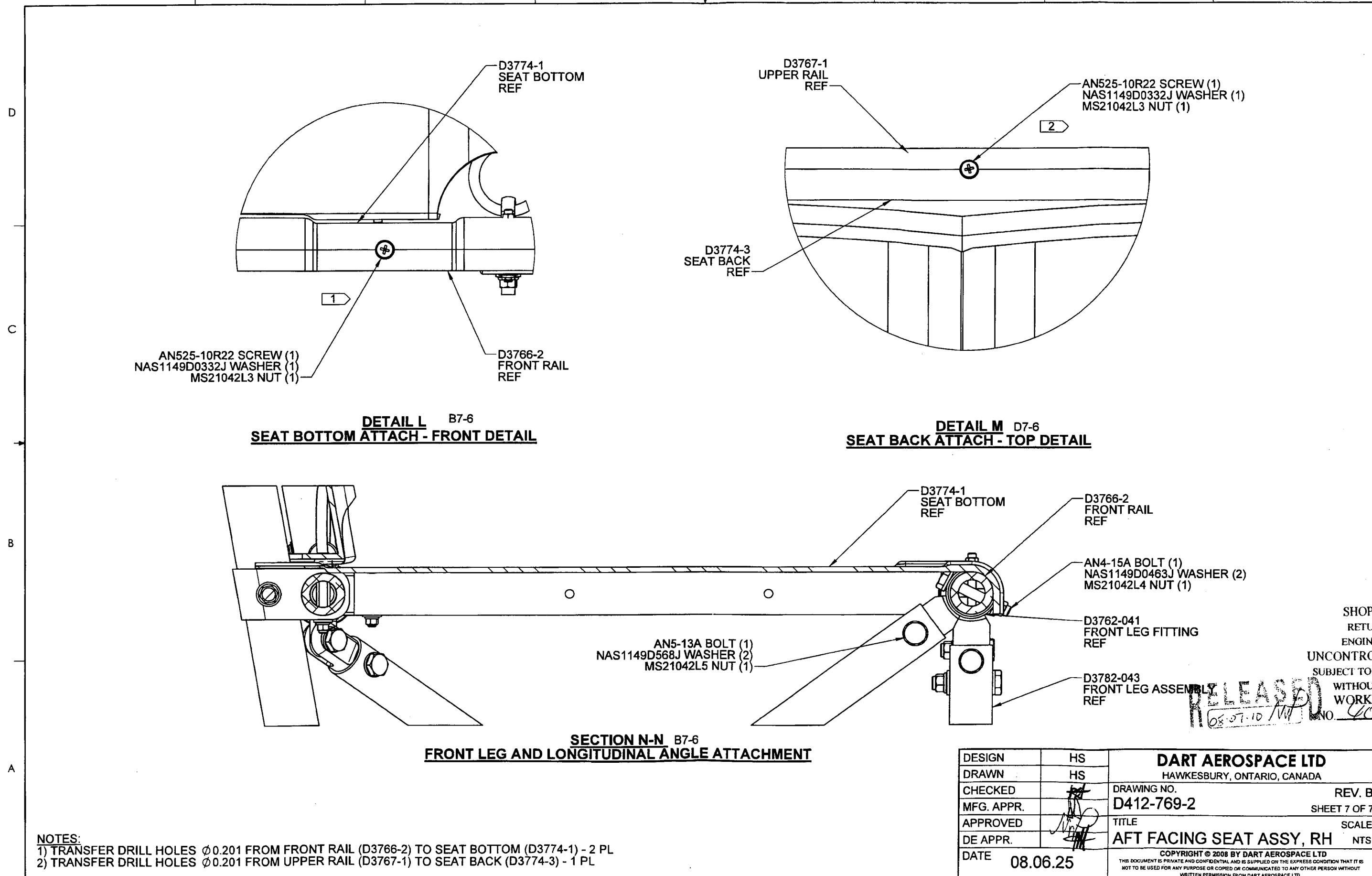
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

